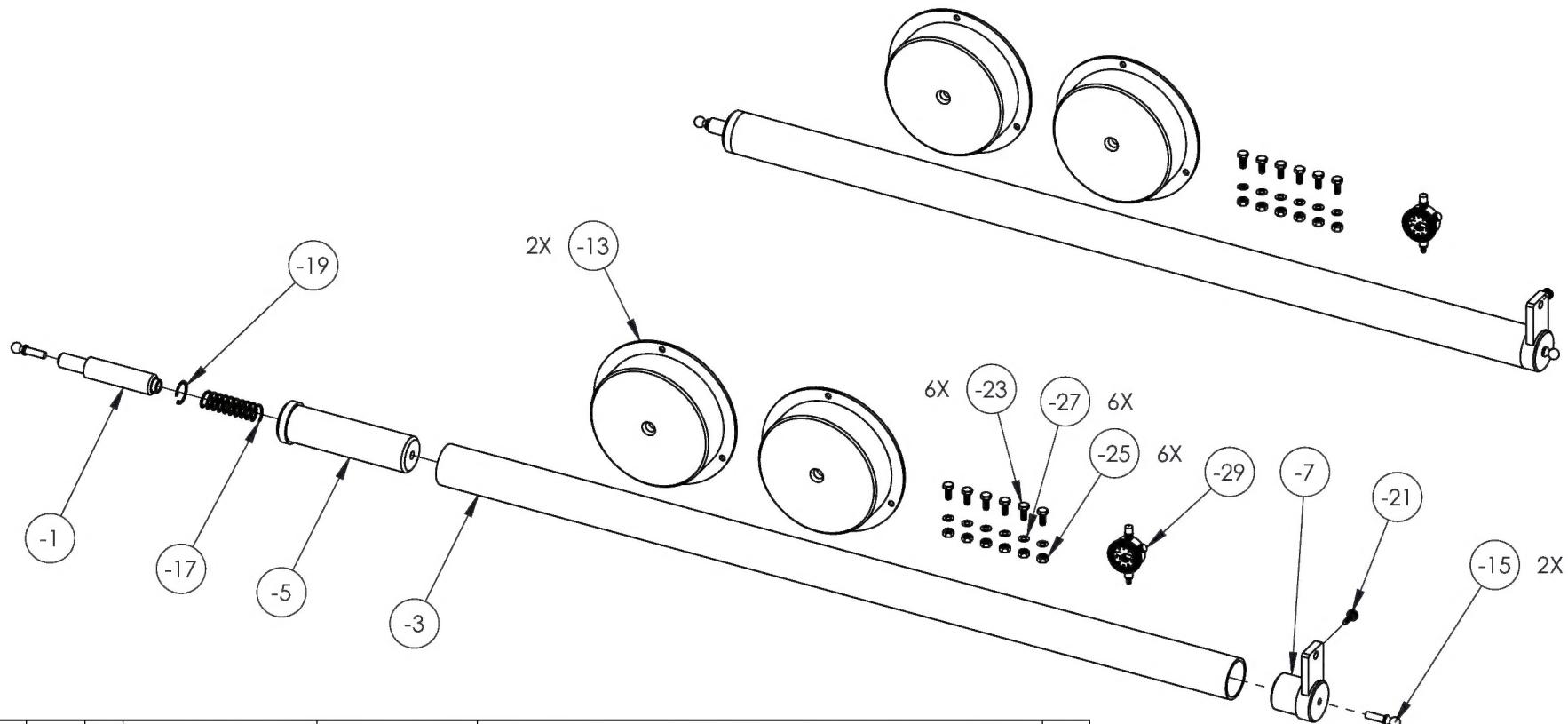


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0233	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D MAT'L WAS 4140 IS 4140 Q&T/4142 Q&T. REMOVED HEAT TREAT. -3 CH'D FINISH WAS ANODIZE GREY IS CLEAR ANODIZE. DELETED ENGRAVE NOTE. -5 & -9 CH'D DIM WAS LIMITS Ø1.7618-1.7624 IS LIMITS Ø1.7610-1.7615.	1/7/2015	DPD	JAG



ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	PLUNGER	4140 Q&T/4142 Q&T		2
		-3	1	TUBE	6061		3
		-5	1	INSERT	1018		4
X		-7	1	WELDMENT			5
1		-9		INSERT 2	1018		6
1		-11		PLATE	1018		7
		-13	2	ADAPTER	4140/4142		8
B/O	-15	2	CONSTRUCTION BALL	STEEL	Ø1/2 X .94, 6-32 X 5/16 (CARR LANE #CL-5-SCB)		1
B/O	-17	1	SPRING	STEEL	Ø.688 I.D. X .850 O.D. X Ø.081 WIRE X 2.75, 15 LBS/IN (CENTURY SPRING #72243)		1
B/O	-19	1	INTERNAL RETAINING RING	STEEL	Ø1 BORE X .042 (MCMASTER-CARR #98409A211)		1
B/O	-21	1	THUMB SCREW	S.S.	10-32 X 3/4 (CARR LANE #CL-23207)		1
B/O	-23	6	BOLT	STEEL	1/4-28 AN4-5		1
B/O	-25	6	NUT	STEEL	1/4-28 MS35650-3252		1
B/O	-27	6	WASHER	STEEL	1/4 AN960-416		1
B/O	-29	1	DIAL INDICATOR		STARRETT AMI-81-231J-W/FBP		1
ASSY							
-7							

**DART**  
AEROSPACE

TITLE  
**D/S ALIGNMENT TOOL**

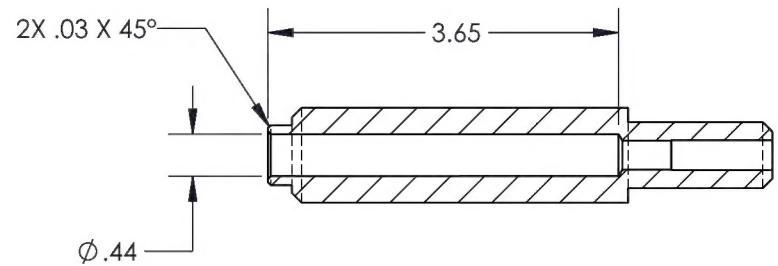
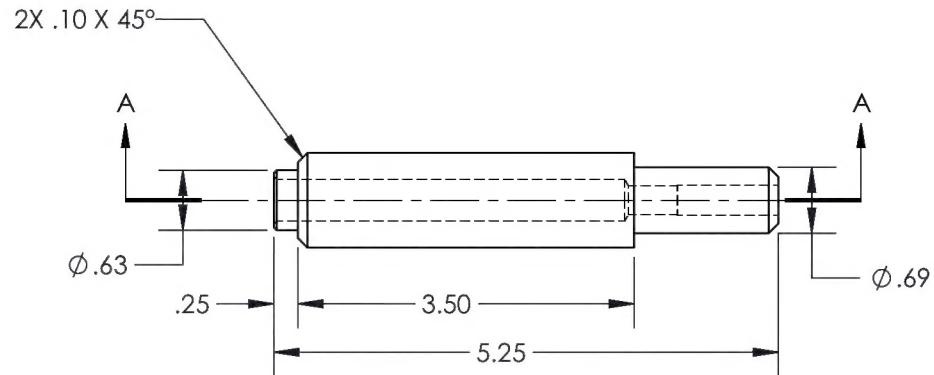
DWG NO. **RB T101743-125**

REV  
**1**

MAT'L	DRAWN BY:	GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED	D Weil
HEAT TREAT FINISH		
SPEC		
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		BELL 412HP
SCALE 1:8	DATE 7/18/2012	SHEET 1 OF 8

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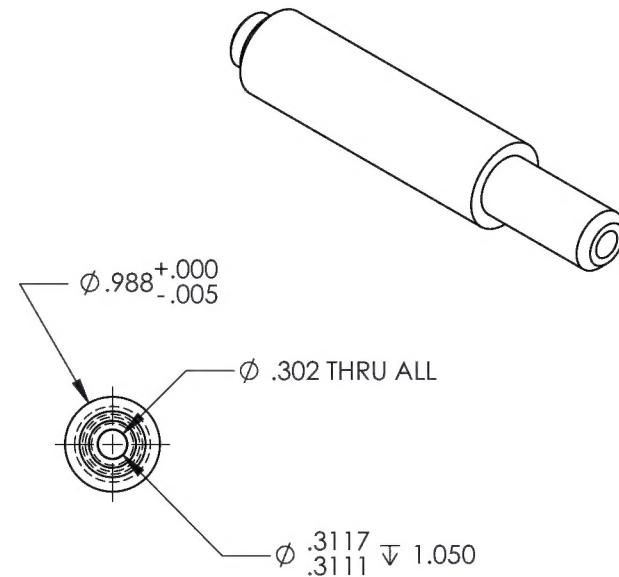
			REVISIONS			
REV	ECR		DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0233	-1	CH'D MAT'L WAS 4140 IS 4140 Q&T/4142 Q&T. REMOVED HEAT TREAT.	1/7/2015	DPD	JAG



SECTION A-A

(-1)

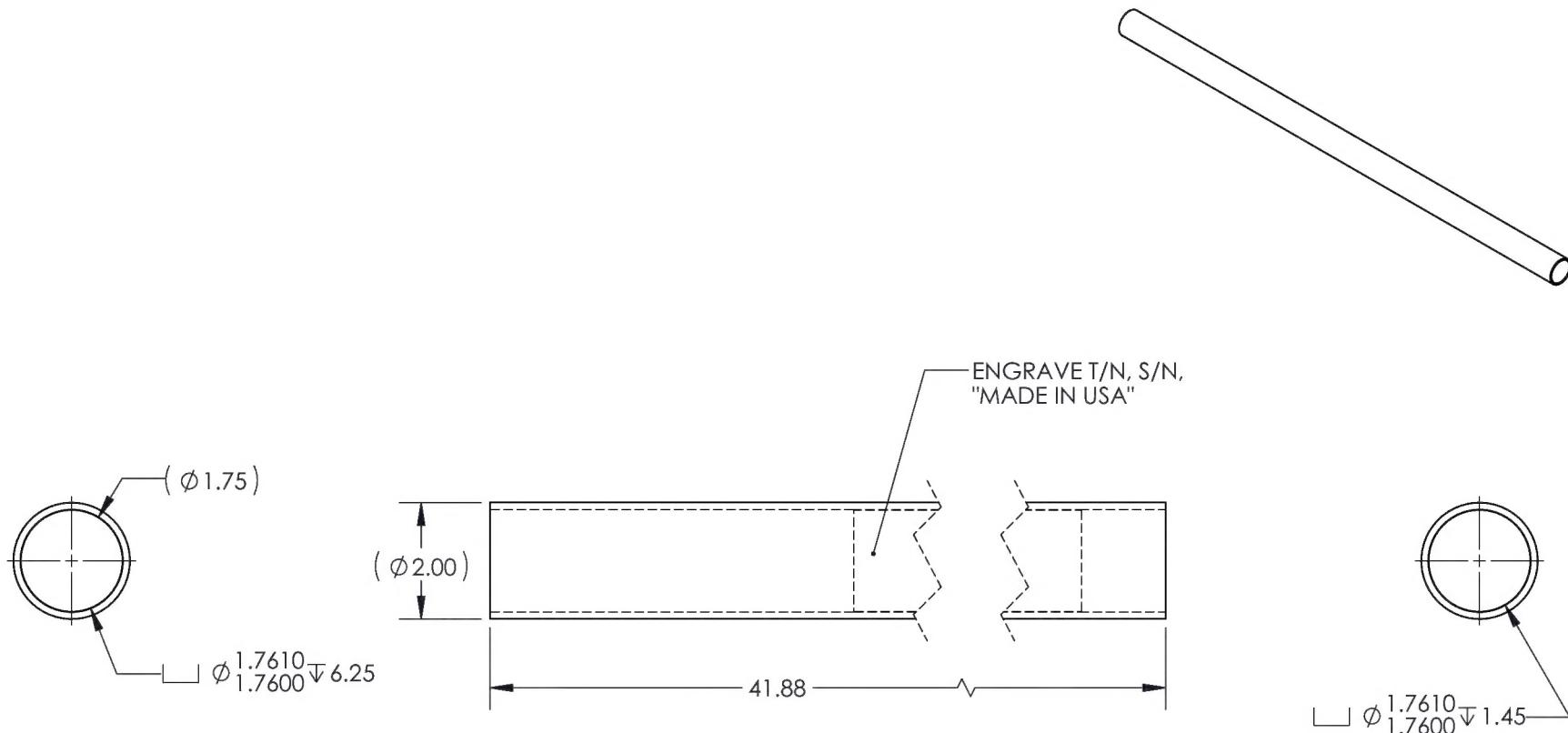
PLUNGER



<b>DART</b> AEROSPACE	
TITLE	
DWG NO. RB T101743-125-1	
REV 1	
MATERIAL 4140 Q&T/4142 Q&T	
DRAWN BY: GILBERT	
APPROVED D Weil	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1	
HEAT TREAT CAD PLATE YELLOW	
SPEC QQ-P-416F, TYPE II, CLASS II	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL BELL 412HP	
SCALE	1:2
DATE	7/18/2012
SHEET 2 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0233	-3 CH'D FINISH WAS ANODIZE GREY IS CLEAR ANODIZE. DELETED ENGRAVE NOTE.	1/7/2015	DPD	JAG



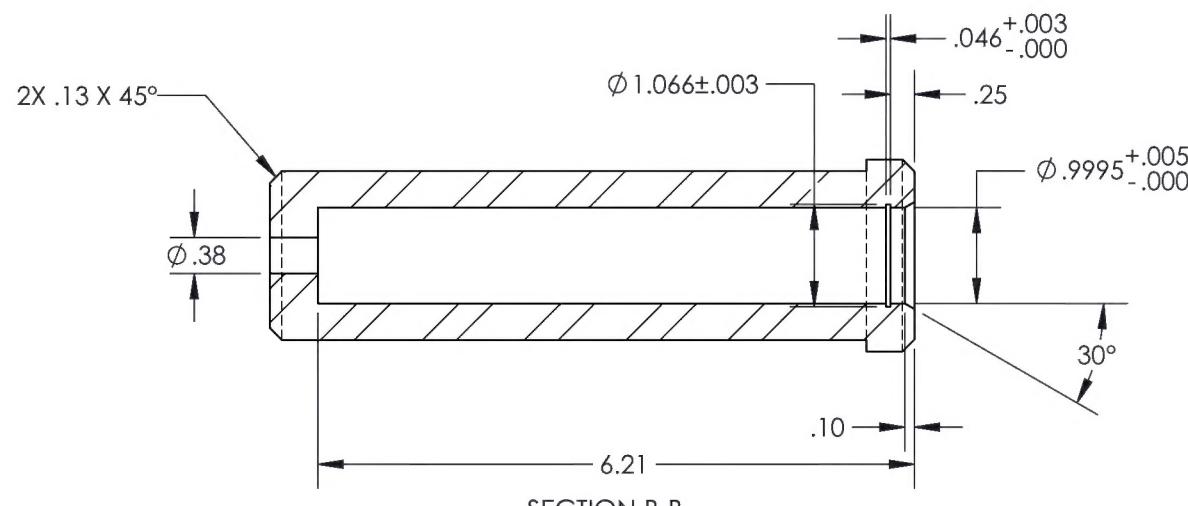
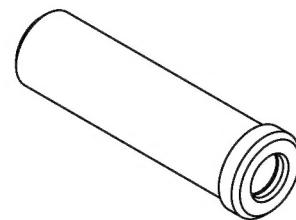
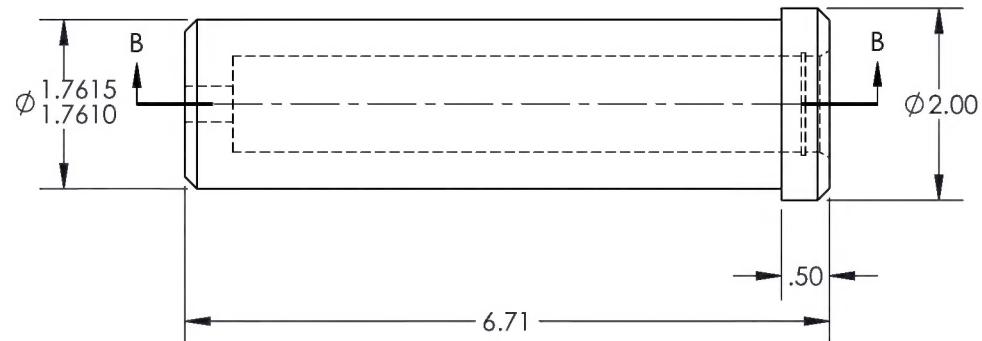
(3)

TUBE

<b>DART</b> <b>AEROSPACE</b>	
TITLE	
DWG NO. RB T101743-125-3	
MAT'L 6061	DRAWN BY: GILBERT
APPROVED D Weil	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER	
PLATING	
SPEC MIL-A-8625F, TYPE II, CLASS II	USED ON MODEL
BELL 412HP	
SCALE 1:3	DATE 7/18/2012
SHEET 3 OF 8	

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REVIEWS		
REV	ECR	DESCRIPTION
1	14-0233	-5 CH'D DIM WAS LIMITS Ø1.7618-1.7624 IS LIMITS Ø1.7610-1.7615.



SECTION B-B

(-5)

INSERT

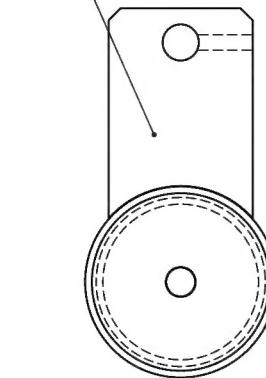
<b>DART</b> AEROSPACE	
TITLE	
DWG NO. RB T101743-125-5	
MAT'L 1018	DRAWN BY: GILBERT
APPROVED <i>D Weil</i>	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER	
PLATING	
SPEC QQ-P-416F, TYPE II, CLASS II	USED ON MODEL
BELL 412HP	
SCALE 1:2	DATE 7/18/2012
SHEET 4 OF 8	

REV  
**1**

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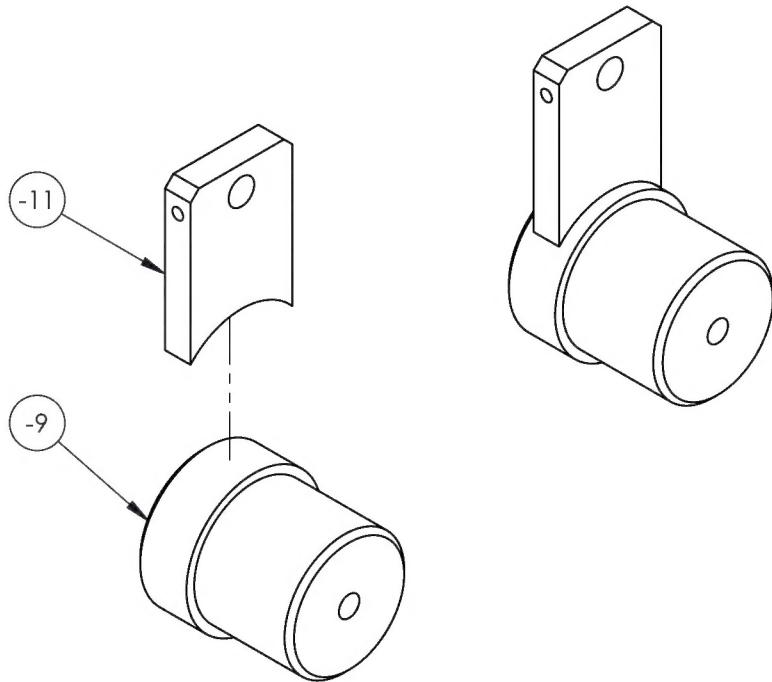
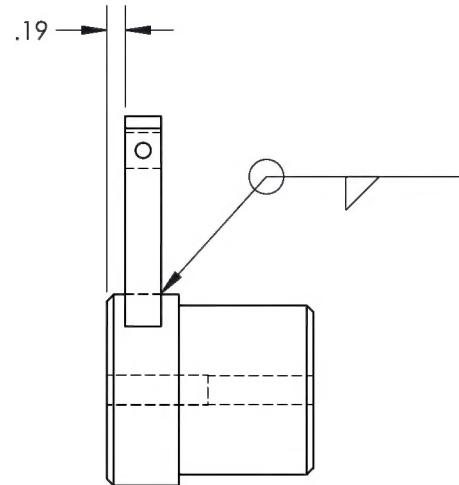
REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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ENGRAVE "RB T101743-107  
RB T101743-101  
OR  
RB T101743-125  
TOOL SET"



(-7)

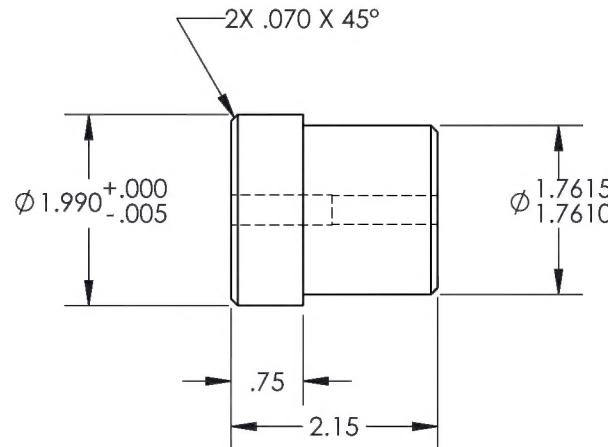
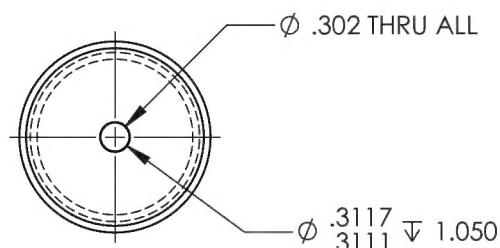
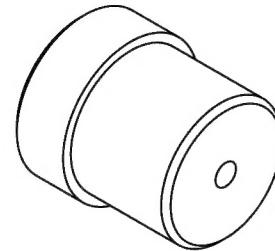
WELDMENT



DART AEROSPACE	
TITLE	
DWG NO. RB T101743-125-7 REV 1	
MAT'L	DRAWN BY: GILBERT APPROVED D Weil
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SPEC QQ-P-416F, TYPE II, CLASS II USED ON MODEL BELL 412HP	
SCALE 1:2	DATE 7/18/2012 SHEET 5 OF 8

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REVISIONS					
REV	ECR		DESCRIPTION	DATE	INITIAL
1	14-0233	-9	CH'D DIM WAS LIMITS Ø1.7618-1.7624 IS LIMITS Ø1.7610-1.7615.	1/8/2015	DPD JAG



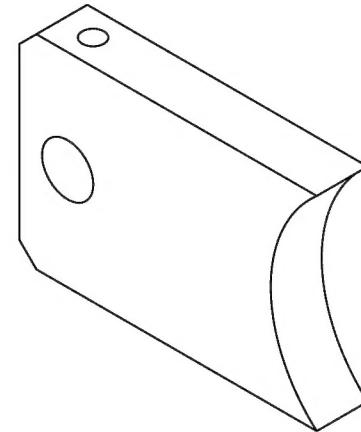
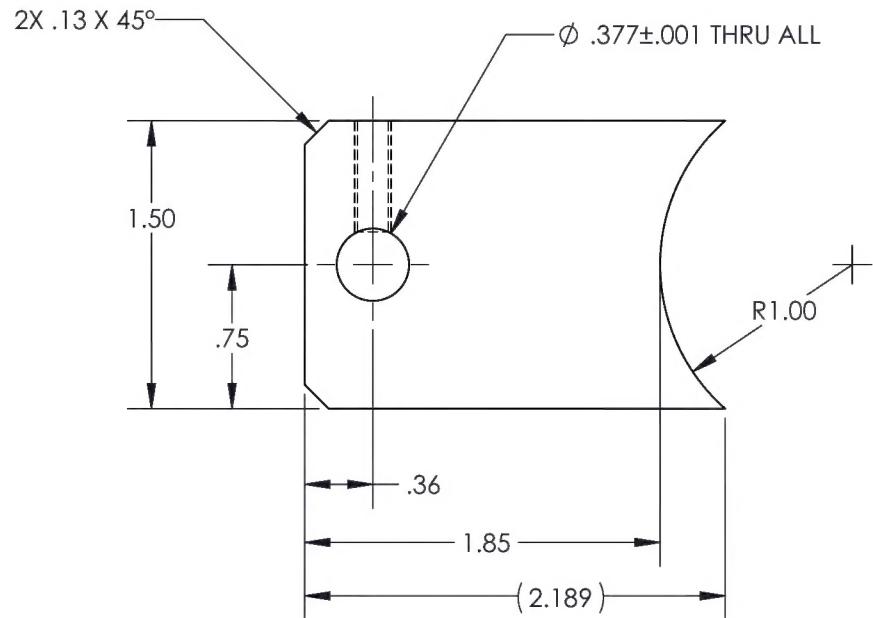
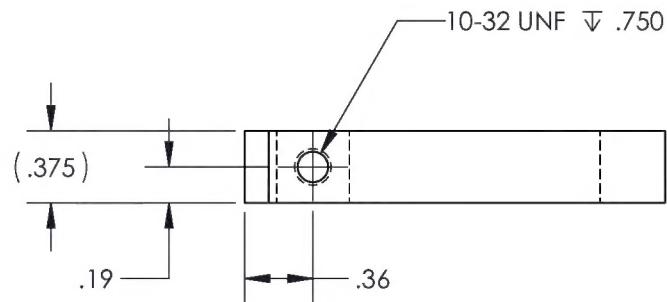
(-9)

INSERT 2

<b>DART</b> AEROSPACE	
TITLE	D/S ALIGNMENT TOOL
DWG NO.	RB T101743-125-9
MAT'L	DRAWN BY: GILBERT
1018	APPROVED <i>D Weil</i>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
X ± .1	SEE -7 WELDMENT
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	1:2
DATE	7/18/2012
SHEET 6 OF 8	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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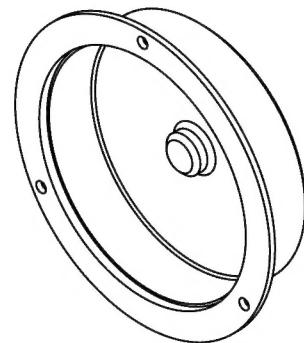
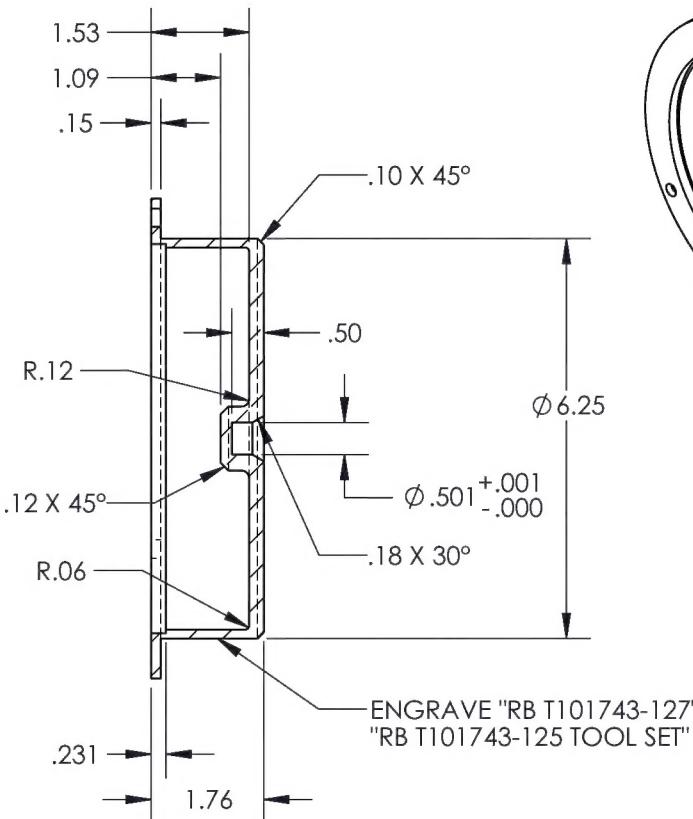
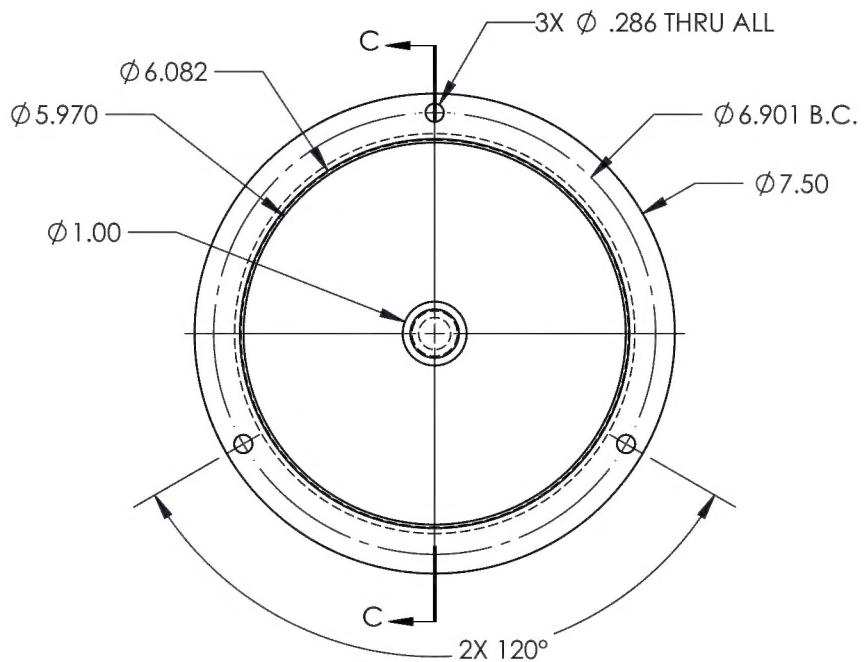
(-11)

PLATE

TITLE		DART AEROSPACE	
DWG NO.		RB T101743-125-11	
MAT'L		1018	
DRAWN BY:		GILBERT	
APPROVED		D Weil	
UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN INCHES			
.XXX ± .005 FRACTIONS ± 1/8			
.XX ± .01 ANGLES ± 5°			
.X ± .1			
HEAT TREAT SEE -7 WELDMENT			
SPEC			
USED ON MODEL			
BELL 412HP			
SCALE	1:1	DATE	7/18/2012
SHEET 7 OF 8			

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
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SECTION C-C

(-13)

ADAPTER

<b>DART AEROSPACE</b>	
TITLE: D/S ALIGNMENT TOOL	
DWG NO.: RB T101743-125-13	REV: 1
MAT'L: 4140/4142	DRAWN BY: GILBERT
APPROVED: D Weil	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
HEAT TREAT FINISH CAD PLATE YELLOW	
SPEC QQ-P-416F, TYPE II, CLASS II	
USED ON MODEL BELL 429HP	
SCALE: 1:3	DATE: 7/19/2012
SHEET 8 OF 8	